

Date: Thursday, 7/13/2006 3:38:09 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: TUBE
Job Number	27900			
Estimate Number	11172			
P.O. Number	N/A			
This Issue	7/13/2006	S.O. No. : N/A	Part Number	: D22827
Prsht Rev.	NC		Drawing Number	: D2282 REV E
First Issue	N/A	Type : MACHINED PARTS	Project Number	: N/A
Previous Run	26817		Drawing Revision	: E
Written By			Material	: N/A
Checked & Approved By		✓ 06-07-13	Due Date	: 8/15/2006
Comment	Est Rev:A	Removed from 9 Digit	Qty:	200
		05-12-02 JLM	Um:	Each

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0675W091	304 RD Tube .675 x .091W 	
Comment: Qty.: 0.0699 f(s)/Unit Total : 13.9860 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) Batch 19524 13.986 f.			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 	
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA190			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK			
5.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 393			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: <i>10</i>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: *PS*Date: *06/09/07*

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 7/13/2006 3:38:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 27900

Part Number: D22827

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



200

Comment: DOCUMENT CONTROL

Inspection Level 21

6/09/07

Job Completion



6/09/07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27900
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

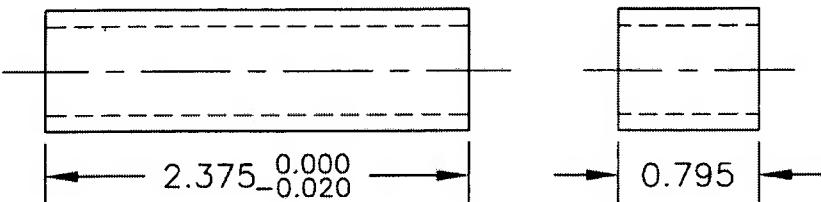
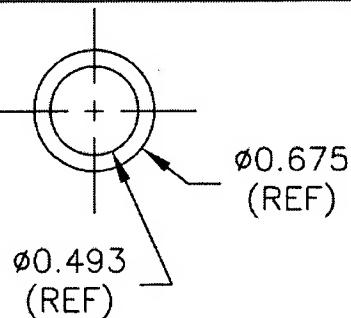
Measured by:	<u>Sumit</u>	Audited by:	<u>BC</u>	Prototype Approval:	N/A
Date:	06-09-07	Date:	06-09-06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	0.795 was 0.750	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	✓

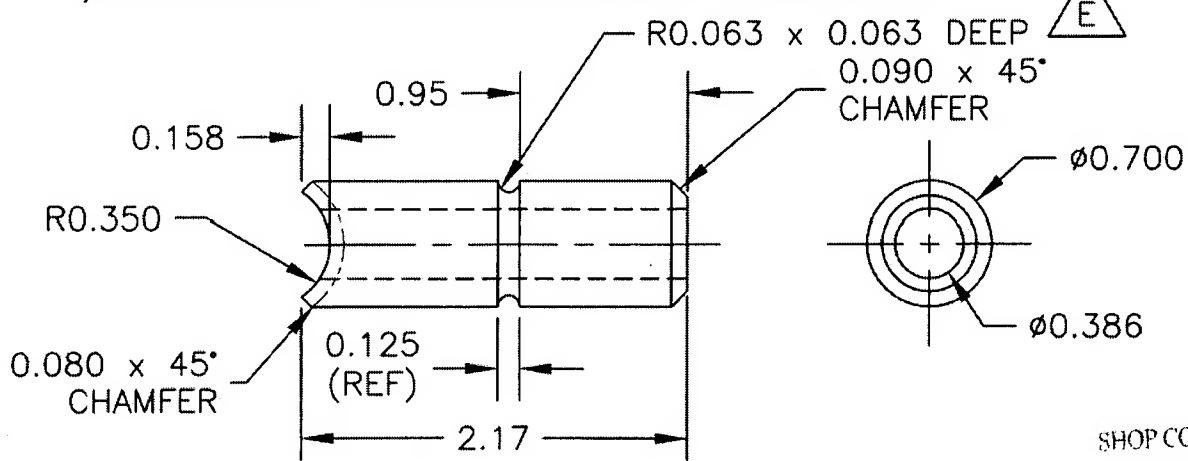
DART

DESIGN BW	DRAWN BY <i>BP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>10/05</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	

RELEASED
10/05
05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

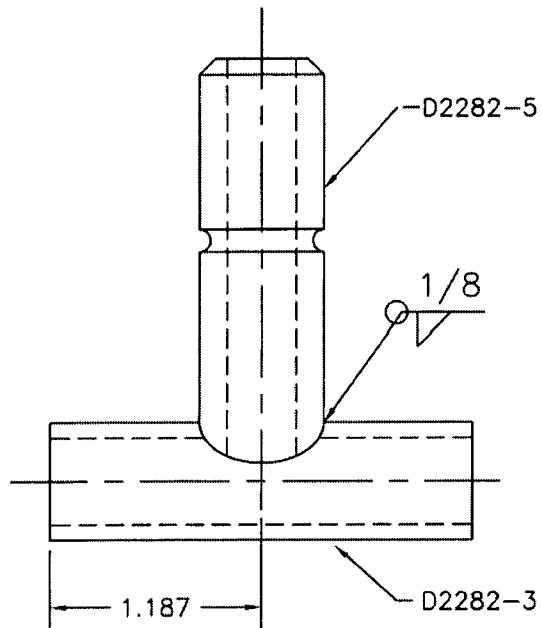
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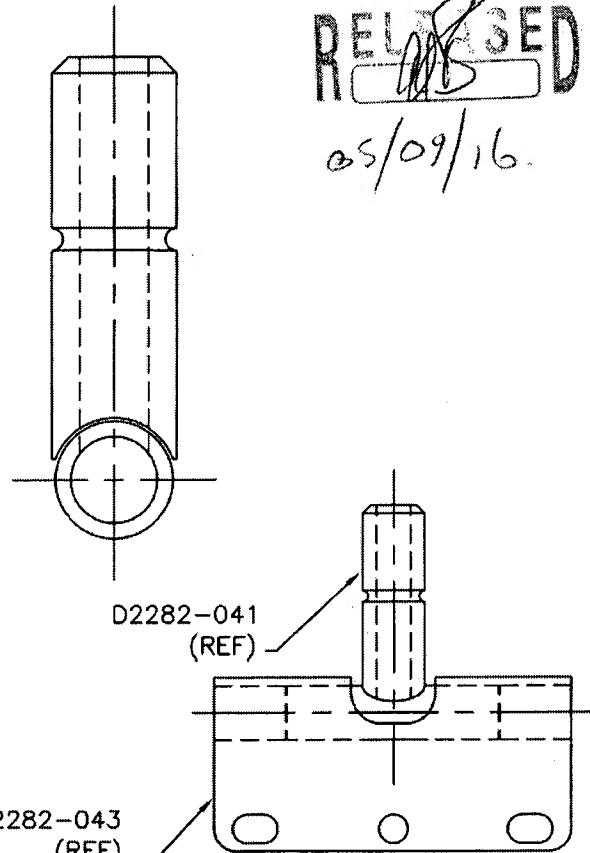
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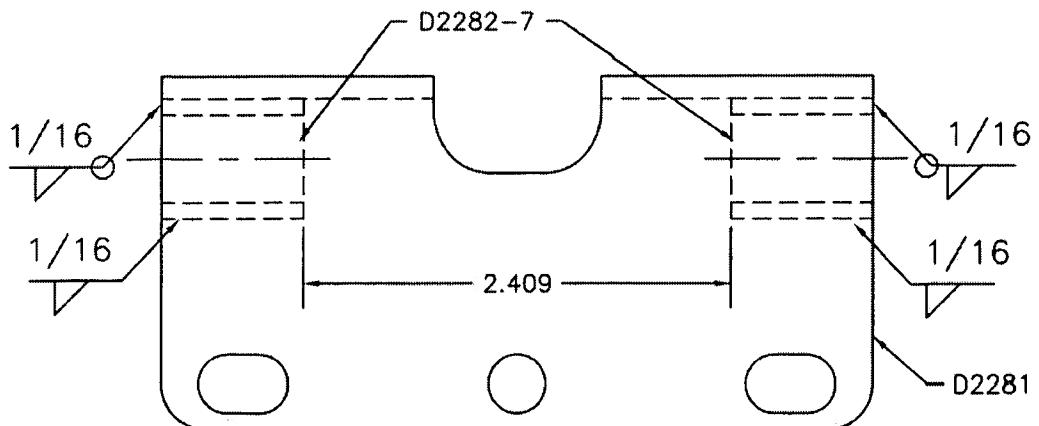
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>MB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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